

Split-2 06.06.08.33

Date: Tuesday, 5/23/2006 8:13:06 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPAD		
Job Number	: 27169 2 -2					
Estimate Number	: 10313					
P.O. Number	: N/A			Part Number	: D26483	
This Issue	: 5/23/2006 S.O. No. : N/A			Drawing Number	: D2648 REV D	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A Type : PURCHASED PARTS			Drawing Revision	: D	
Previous Run	: 25904			Material	: N/A	
Written By	: See Comment below			Due Date	: 6/5/2006	
Checked & Approved By	: OK 06.05.23			Qty:	400	Um: Each
Comment	: Est: E 02.09.18 Re-format; Incorporated D2648-1 KJ/RF					

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 1312
 Email or ship DXF file to vendor
 Make per Drawing D2648-1
 Material release note required

C Yoceros/24

400

2.0 D26483F Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 400.0000 Each(s)

WEARPAD

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage
 Ensure material release note is attached

18.06.06/01/02

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

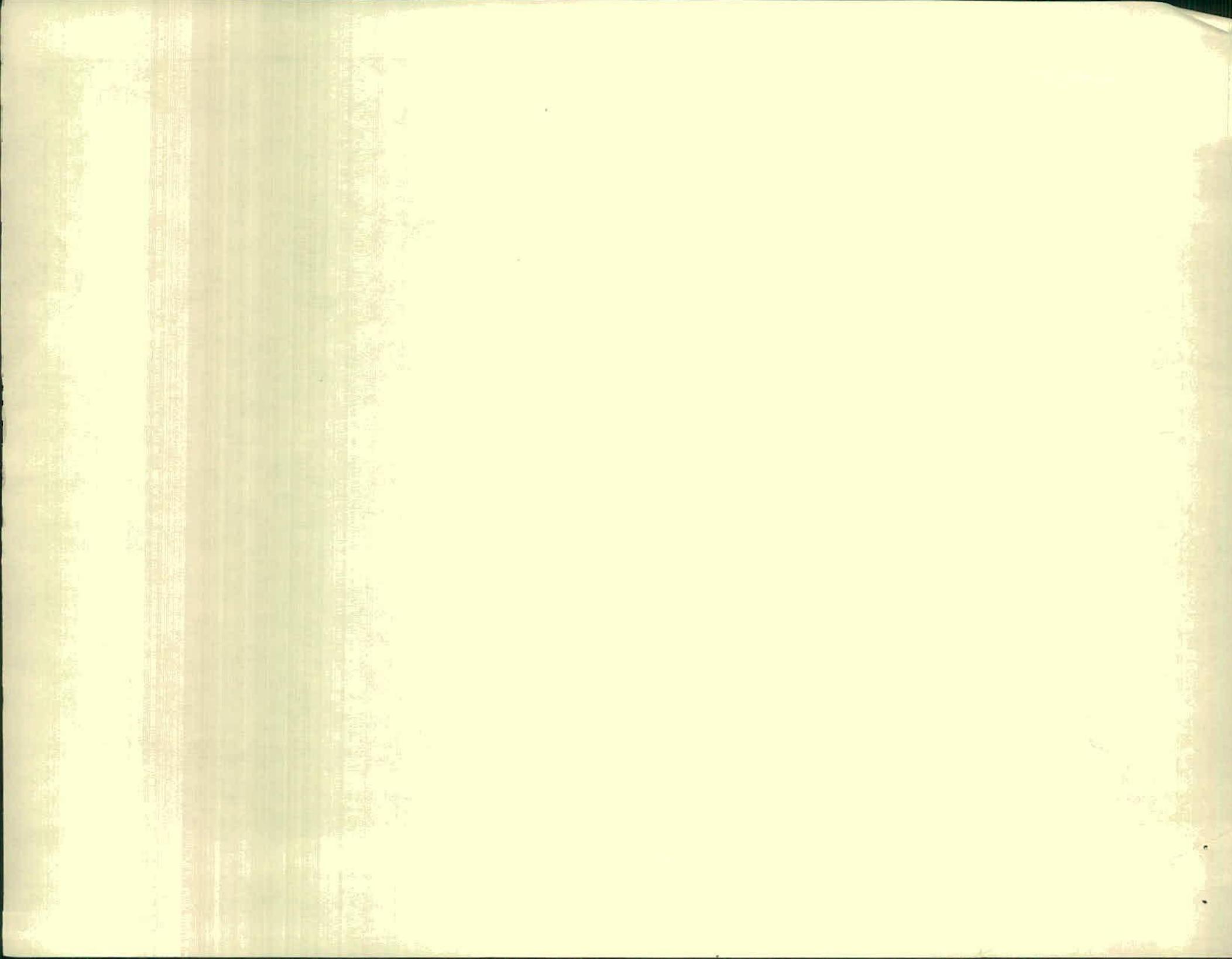
5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

N/A SA 06/06/06 40



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Drawing Name: WEARPAD

Job Number: 27169

Part Number: D26483

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326.

2-Identify as D2648-3

SAD

06/06/02

402

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch

A/R560Hardcoat M100942 M101217

1-Weld as per Dwg D2648 using Jig DT 8210

2-Remove any weld that penetrated through Wearpadif necessary

H.M 06/06/13

402

8.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DL 06/06/13 402

10.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

DL 06/08/02

182

P0

11.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL 06/08/02 182

12.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FFP 15

DL 06/08/02 182

182

13.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DL 06/08/09

182

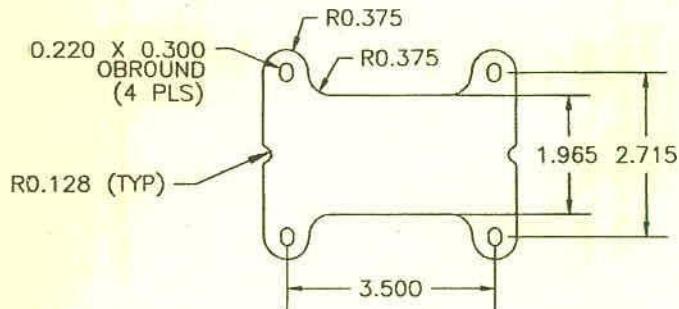
DL 06/08/08

OC (OS/OS)

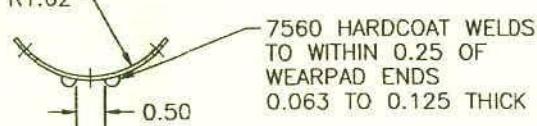
10.0

split w/o. need qty of 182 on split -2
qty remaining 220 on ~~this~~ original

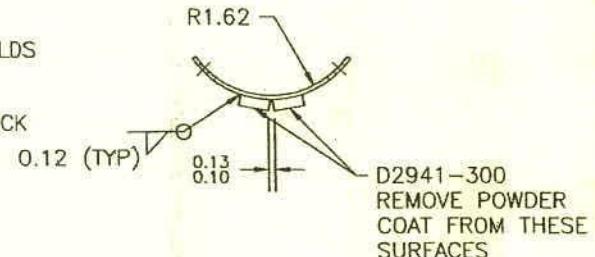
D2648-1 FLAT PATTERN



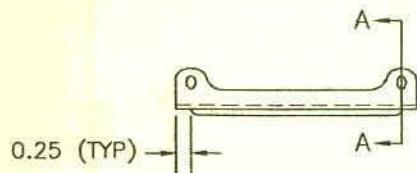
SECTION A-A



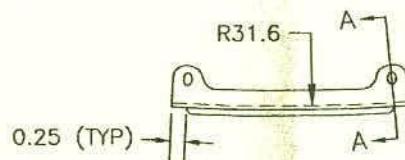
SECTION B-B



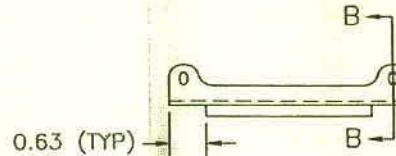
D2648-3 LONGITUDINAL BEND
(MADE FROM D2648-1)



D2648-5 LONGITUDINAL BEND
(MADE FROM D2648-1)



D2648-7 LONGITUDINAL BEND
(MADE FROM D2648-1)



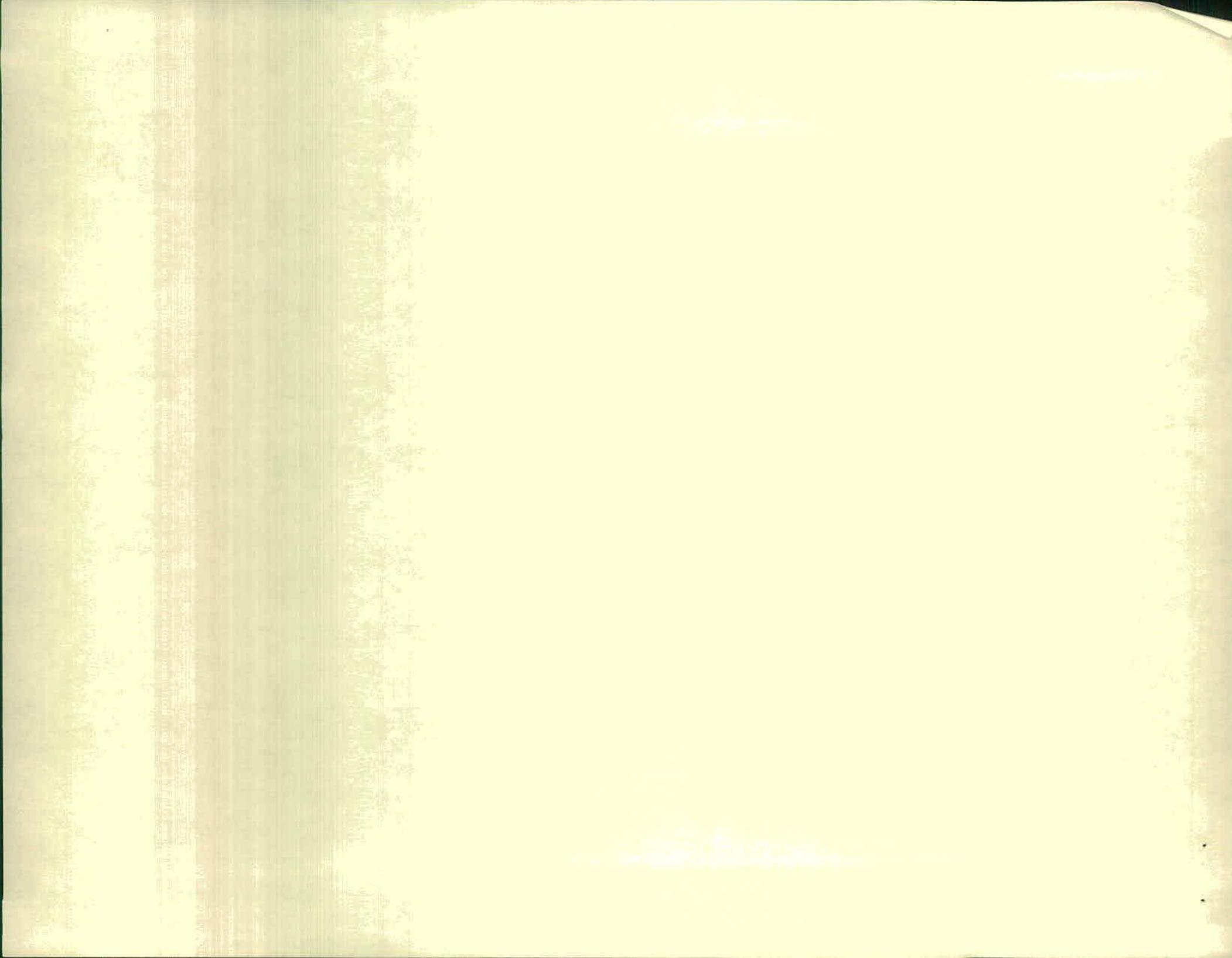
BREAK ALL SHARP CORNERS 0.063 MAX
MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)
FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

NO. 27169
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

D	99.11.17	ADDED D2648-7
C	97.06.26	R31.6 WAS R19.6
B	97.05.30	ENLARGE OBROUND, 0.375 WAS 0.250
A	97.03.25	NEW ISSUE
DESIGN	DRAWN BY RF	DART DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. REV. D D2648 SHEET 1 OF 1
DATE	99.11.17	TITLE WEARPAD SCALE 1:2

RELEASED
4.12.20 D5







California Steel Industries
14000 San Bernardino Ave.
Fontana, California 92335
Ph (909) 350-6300

PL-337148
100V 55/1013 MDC

CERTIFIED TEST REPORT

8

CUSTOMER ORDER PS0614ME002		MO. NUMBER 02-8344-01	-SHIPPING DATE 08/01/05	CAR NUMBER RR: WCTR142061	TALLY NUMBER PO 250499136 1/
B L L T O	WILKINSON STEEL AND METALS A DIVISION OF PREMETAL CO., INC. 888 S.E. MARINE DR., VANCOUVER BC, CANADA, V5X2V3	S H I P T O	WILKINSON STEEL-METALS C/O GARY R. HAMILTON TRUCKING 888 S.E. MARINE DR., VANCOUVER BC, CANADA	BC	V5Y 2

MARK ALL DOCUMENTS W/P.O. PS0614ME002. FAX TALLIES AT TIME OF SHIPMENT TO MEL ELIAS FAX #604-301-3244.

END USE	WAREHOUSE STOCK - NON-CRITICAL SURFACE				
PROD	H.R. COILS - P & O - PRIME				
SPEC	ASTM-A-1011-00-CS-TYPE B				
T/R	INSPECTION MILL				
DESCRIPTION .0605 x 48.0000 x COIL NOM ME		COILS, PIECES OR BUNDLES	HEAT NUMBER		
		1 1	T42354 T42348		
<p>I CERTIFY THE FOLLOWING TEST INFORMATION TO BE CORRECT AS CONTAINED IN THE RECORDS OF THE COMPANY.</p>  <p>CHIEF - LABORATORY SERVICES</p>					

HEAT OR LOT NUMBER	SLAB NUMBER	LOC	YIELD KSI	TENSILE STRENGTH KSI	% ELONGATION		BEND TEST	CHEMICAL ANALYSIS										10:48:05		08/01/05		CC	
					#	7"		C	Mn	P	S	Si	Cu	Ni	Cr	Mo	Al	V	Cb	T1	N		
T42354					08	.39	010	006	006	01	01	01	00	050	000	000	000	000	000	000	000	000	
T42348					08	.38	014	010	007	01	01	01	00	046	000	000	001	003					

CTR-001 PTLUG2L 980712

